



Dart Aerospace Ltd.  
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**D3507-1-BENT**  
**Job Sheet 183670**



**Part No:** D3507-1-BENT

**Job Qty:** 8 ea

**Part Name:** Skidtube Assembly EC135



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 9/24/18

**Job Tracking No:**

**Due Date:** 10/12/18

**Created By:** Jesse White

**Type:** Stock

**Description:** SIOP

**Note:** DWG REV D IPP rev A 10.09.17 new issue EC verified by:DD

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation           | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|---------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                     |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 90    | Start up Operation  | 8 Ea  | 10/12/18   | 10/12/18 | 0.00      | 0.00    | Start Up Skid tubes-3 |           | M/6/1    |
| 120   | CNC Bend Skid tubes | 8 pcs | 10/12/18   | 10/12/18 | 0.33      | 4.71    | CNC Bend Skid tube    |           | M/6/1    |
| 140   | QC                  | 8 pcs | 10/12/18   | 10/12/18 | 0.00      | 0.00    | QC5                   |           | BE       |
| 300   | Packaging           | 8 pcs | 10/12/18   | 10/12/18 | 0.00      | 0.00    | Packaging3-1          |           | BE       |
| 310   | QC21-SA             | 8 Ea  | 10/12/18   | 10/12/18 | 0.00      | 0.00    | QC21                  |           | BE       |

Part Op 120 - 1- Bend tube as per program D3507 on CNC Bender FOLIO 6 and Dwg D3507, use DT9632 bending aide 2- Cut  
Descriptions: FWD END of tube as per dwg D3507  
300 - LOCATION : LG002

### Job BOM

| Part / Item | Component Name           | Quantity    | Operation             | Container |
|-------------|--------------------------|-------------|-----------------------|-----------|
| D2962-150   | 3.540 Outer Tube, Extrut | 8 Ea (1 ea) | 90-Start up Operation | 5084714   |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | D2962-150      | 8        | 68        | 0         |

### Part Specifications

Specifications could not be found.

Plex 9/24/18 10:15 AM dart.white.jesse

**DART**  
AEROSPACE

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Container No: S117522



Part: D3507 - 1 - BENT

Job No: 182670

Serial: 117522

Revision:

Inspector:

Exp Date

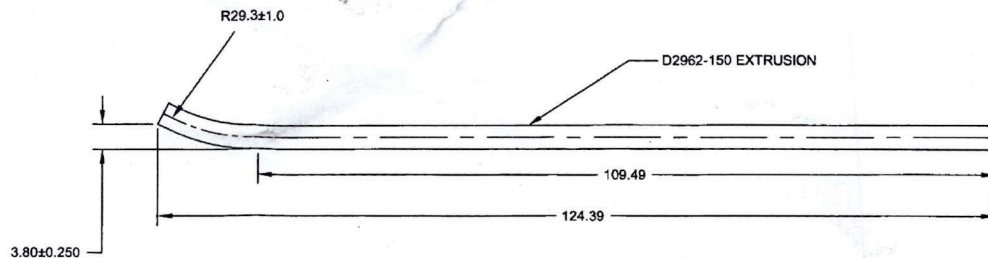
Instructions: Various STC's

Date: 10/11/18

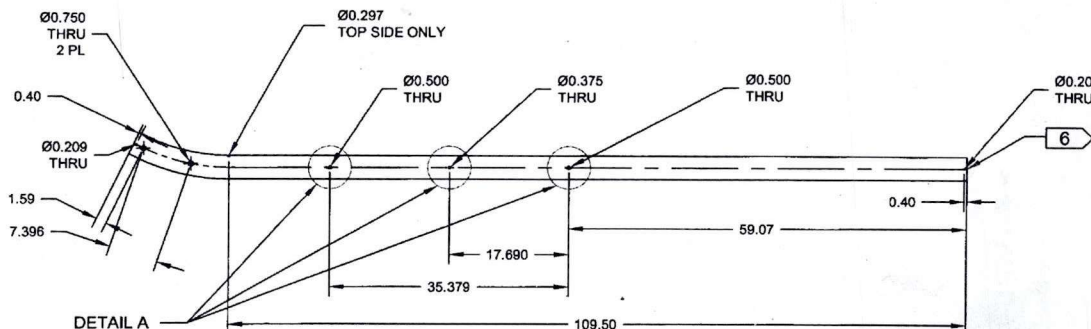
| Qty | Part Number   | Description       |
|-----|---------------|-------------------|
| X   | D3507-041     | SKIDTUBE ASSEMBLY |
| 1   | D2962-150     | EXTRUSION         |
| 1   | D2965         | CAP               |
| 1   | D2965-3       | CAP               |
| 4   | D3492-041     | PLUG ASSEMBLY     |
| 4   | D3492-043     | PLUG ASSEMBLY     |
| 2   | D3492-047     | PLUG ASSEMBLY     |
| 2   | D3504-1       | CROSS BOLT SPACER |
| 1   | D3504-3       | CROSS BOLT SPACER |
| 2   | D3504-5       | CROSS BOLT SPACER |
| 1   | D3505-1       | WEB               |
| 4   | D3506-1       | DOUBLER           |
| 2   | D3506-3       | DOUBLER           |
| 1   | D4918-1       | WEARPLATE         |
| 1   | D4918-3       | WEARPLATE         |
| 1   | D4918-5       | WEARPLATE         |
| 1   | D4918-047     | WEARPLATE         |
| 38  | AELS-1032-130 | INSERT            |
| 1   | AELS-1032-225 | INSERT            |
| 31  | AN3C4A        | BOLT              |
| 2   | AN3C5A        | BOLT              |
| 2   | AN526C1032-10 | SCREW             |
| 33  | AN960C10L     | WASHER            |
| 12  | MS20801AD4W3  | RIVET             |

# GENERAL NOTES:

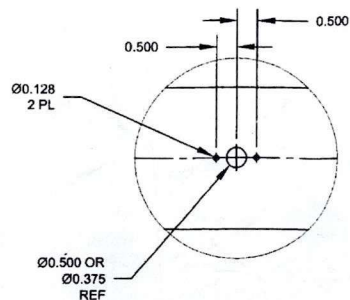
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB.  
STANDARD: PRIME (REF. 4.2 1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.  
OPTIONAL: POWDER COAT WHITE (REF 4.3 5.1) PER DART QSI 005 4.3.  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTERLINE PER DART QSI 005 4.4 (OPTIONAL)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART B/N PER DART QSI 044 6.4 (VIBRATING STYLUS) ON I.D. OF TUBE.
- 7) WEIGHT: 24.1 LB (FROM IIN-D135-751)
- 8) WELDING TO BE DONE PER DART QSI 004
- 9) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 10) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/291.
- 11) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS



**D3507-1 BENDING/CUTTING DETAIL**



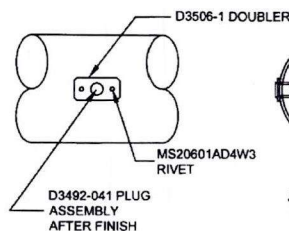
**D3507-1 DRILLING DETAIL**



**DETAIL A**  
TYP, 6 PL  
SCALE 3:10

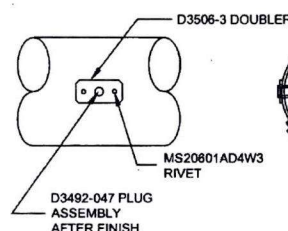
|                                                                                                                                                                                                                                                                                         |                                                                                                                     |                                            |              |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------|--------------------------------------------|--------------|
| D                                                                                                                                                                                                                                                                                       | REMOVE D3558-X GASKETS, D4918-X WAS D3508-X<br>REVISE FINISH TO ADD PAINT AS THE<br>PREFERRED FINISH. REVISED NOTES | DW                                         | 13.08.30     |
| C                                                                                                                                                                                                                                                                                       | ADD D3504-5, FOR SKID GEAR DEFLECTOR;<br>CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW                                 | DC                                         | 07.09.19     |
| B                                                                                                                                                                                                                                                                                       | ADD GASKET, CHANGE HARDWARE MAT'L                                                                                   | PH                                         | 06.11.01     |
| A                                                                                                                                                                                                                                                                                       | NEW ISSUE                                                                                                           | PH                                         | 06.04.21     |
| REV.                                                                                                                                                                                                                                                                                    | DESCRIPTION                                                                                                         | BY                                         | DATE         |
| DESIGN                                                                                                                                                                                                                                                                                  | DW                                                                                                                  | <b>DART AEROSPACE USA, INC</b><br>KENT, WA |              |
| DRAWN                                                                                                                                                                                                                                                                                   | DW                                                                                                                  |                                            |              |
| CHECKED                                                                                                                                                                                                                                                                                 | JP                                                                                                                  |                                            |              |
| MFG. APPR.                                                                                                                                                                                                                                                                              | JP                                                                                                                  |                                            |              |
| APPROVED                                                                                                                                                                                                                                                                                | JP                                                                                                                  |                                            |              |
| DE APPR.                                                                                                                                                                                                                                                                                | JP                                                                                                                  | DRAWING NO.                                | REV. D       |
| DATE                                                                                                                                                                                                                                                                                    | 13.08.30                                                                                                            | D3507                                      | SHEET 1 OF 2 |
|                                                                                                                                                                                                                                                                                         |                                                                                                                     | TITLE                                      | SCALE        |
|                                                                                                                                                                                                                                                                                         |                                                                                                                     | EC 135 SKIDTUBE                            | NTS          |
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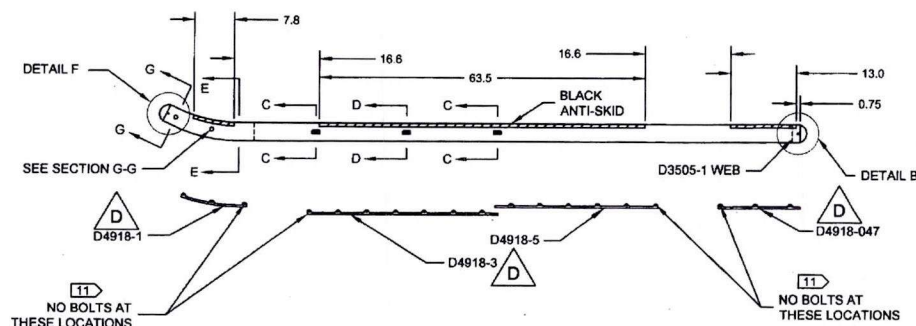
**SECTION C-C**  
(SCALE 3:10)

- D3504-1 CROSS BOLT SPACER**
- AFTER BENDING AND DRILLING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.500 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
  2. INSERT D3504-1 CROSS BOLT SPACER 2 PL
  3. WELD INTO PLACE AND GRIND FLUSH
  4. IF REQUIRED, PASS Ø0.404 (Y" DRILL) THRU HOLE
  5. INSTALL D3506-1 DOUBLER 4 PL USING MS20601AD4W3 RIVET 8 PL
  6. AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY 4 PL

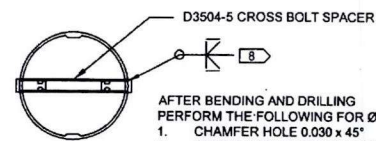


**SECTION D-D**  
(SCALE 3:10)

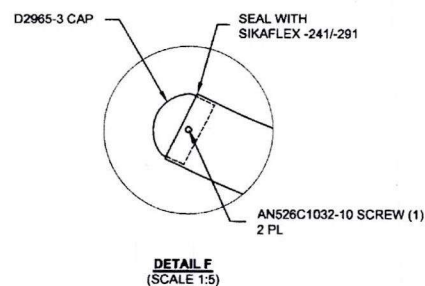
- D3504-3 CROSS BOLT SPACER**
- AFTER BENDING AND DRILLING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
  2. INSERT D3504-3 CROSS BOLT SPACER 1 PL
  3. WELD INTO PLACE AND GRIND FLUSH
  4. IF REQUIRED, PASS Ø0.277 (J" DRILL) THRU HOLE
  5. INSTALL D3506-3 DOUBLER 2 PL USING MS20601AD4W3 RIVET 4 PL
  6. AFTER FINISH, INSTALL D3492-047 PLUG ASSEMBLY 2 PL



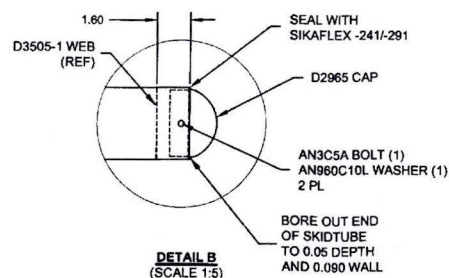
**D3507-041 ASSEMBLY DETAIL**



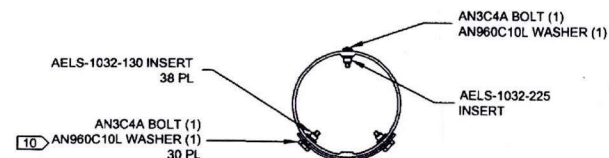
- AFTER BENDING AND DRILLING  
PERFORM THE FOLLOWING FOR Ø0.750 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
  2. INSERT D3504-5 CROSS BOLT SPACER 2 PL
  3. WELD INTO PLACE AND GRIND FLUSH
  4. IF REQUIRED, PASS Ø0.594 (19/32 DRILL) THRU HOLE
  5. AFTER FINISH, INSTALL D3492-043 PLUG ASSEMBLY 4 PL



**DETAIL F**  
(SCALE 1:5)



**DETAIL B**  
(SCALE 1:5)



**SECTION E-E**  
(SCALE 3:10)

|            |          |                                                                                                                                                                                                                                                                                    |              |
|------------|----------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | Dw       | <b>DART AEROSPACE USA, INC</b>                                                                                                                                                                                                                                                     |              |
| DRAWN      | Dw       | KENT, WA                                                                                                                                                                                                                                                                           |              |
| CHECKED    | GP       | DRAWING NO.                                                                                                                                                                                                                                                                        | REV. D       |
| MFG. APPR. | JP       | D3507                                                                                                                                                                                                                                                                              | SHEET 2 OF 2 |
| APPROVED   | JP       | TITLE                                                                                                                                                                                                                                                                              | SCALE        |
| DE APPR.   | JP       | EC 135 SKIDTUBE                                                                                                                                                                                                                                                                    | NTS          |
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